Work Order ID 69743 Page 1 Wednesday, May 18, 2011 11:02:34 AM Item ID: D3535-25 Accept Setup Start **Revision ID:** Stop Item Name: Wearshoe Start Qty: 20.00 Start Date: 5/18/2011 **Cust Item ID:** Req'd Qty: 20.00 Required Date: 5/20/2011 **Customer:** Reference: Start Run Date: 11-05-18 Tooling: Process Plan: Approvals: Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. Work Center ID Description Qty Qty **Run Hours** Code Number Stamp **Revision Nbr** Draw Nbr D3535 Rev B 100 0.00 FLOW WATER JET 1311-6-1 0.00 Waterjet Memo □Prog Rev: R □2-FLOW CNC Waterjet 1-Cut as per Dwg D3535 □Dwg Rev: Deburr if necessary 304,040 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B11-6-1 0.00 Memo Quality Control QC8- Inspect parts - second check 0.00 120 8 wholes 0.00 QC Memo Quality Control

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Wednesday, May 18, 2011 11:02:34 AM

Page 2

Item ID: D3535-25 **Revision ID:** Wearshoe Item Name: 5/18/2011 **Start Qty: 20.00 Start Date:** Required Date: 5/20/2011 Reg'd Oty: 20.00 Reference: Process Plan: Approvals: QC: Sequence ID/ Operation Work Center ID Description 130 NC BRAKE Brake NC Brake NC 140 Quality Control 150 Powdercoat Powder Coating 1115128



	0.00	
		(25)
Memo	0.00	
1-Form on CNC Brake as per Dwg D3535 u Form joggle on Punch as per Dwg D3535 us	sing Jigs DT8261and DT8326 2- ing Jig DT81581dentify as D3535-25 Sby 106602	•

Tool # Plan

Code

Tool ID

OC5- Inspect part completeness to step on W/O

Set Up/

Run Hours

Reject

Qty

Accept

Qty

Reject

Number

Insp.

Stamp

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 Memo □OVEN TEMPERATURE:

Date:

Memo

START TIME: 10

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Work Order ID 69743

Wednesday, May 18, 2011 11:02:34 AM



Page 3

Item ID:

D3535-25

Accept



Setup Start

Stop



Revision ID:

Item Name:

Wearshoe

Start Date:

Required Date: 5/20/2011

5/18/2011

QC:

Start Oty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run Start

Stop



Sequence ID/ Work Center ID

160

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number

Insp. Stamp

Quality Control

170

Packaging Packaging

Identify as per dwg & Stock Location: FP-18

0.00

25 Bl 11-6-9

25 Bl 11-6-9.

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

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Picklist Print

Wednesday, May 18, 2011 11:02:40 AM

Work Order ID: 69743

D3535-25 Parent Item:

Parent Item Name: Wearshoe



Start Date: 5/18/2011

Required Date: 5/20/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

Verified By:EC IPP Rev:B As per Rev B 07-08-31 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No		100	sf	80.7000	0.51	10.73684	13	ŕ	
									B	1-6-1		

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	80.7	
116623	0.2	
117550	80.5	

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DART AEROSPACE LTD	Work Order:	69143
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	

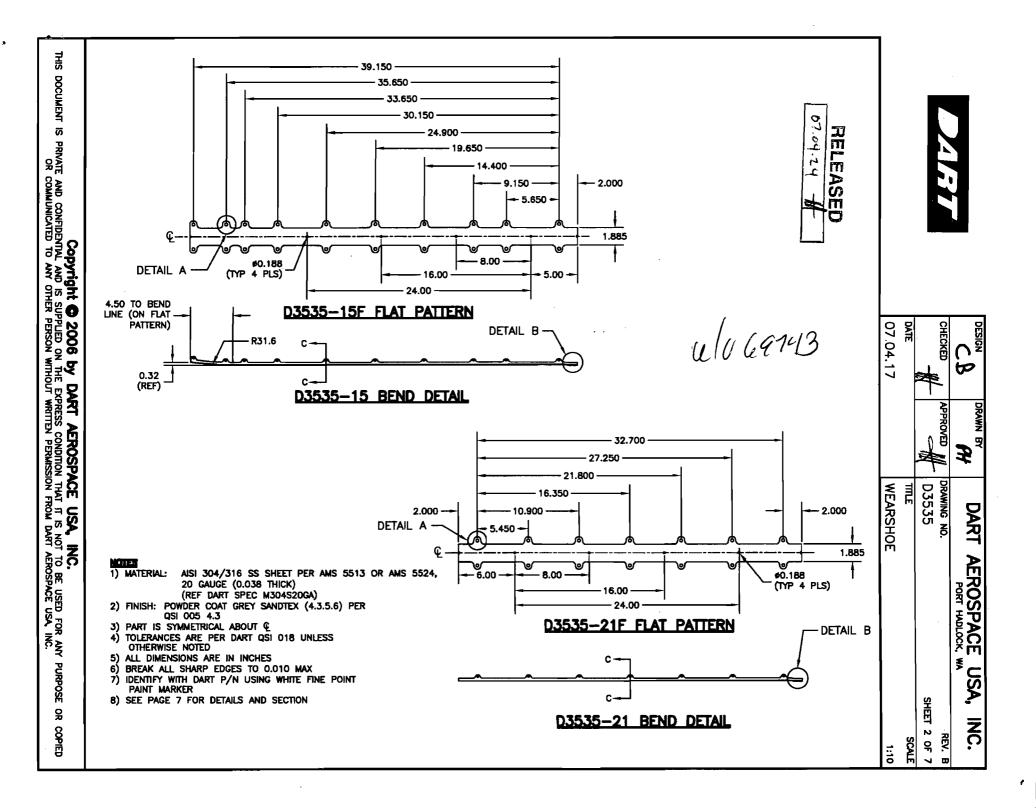
Drawing	Tolerance		Accept	Reject	Method of	Comments
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1.450	+/-0.010	1.420	7		V	,
5.450	+/-0.010	5.450	9		T BG1	
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Ø0.188	+0.005/-0.001	1193	8		V	
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6.75	+/-0.030	6,75	ス		T	
6.00	+/-0.030	6,00	2		7	
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0.038	+/-0.010	,୦3%	≥ €		V	
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Measured by:	B	Audited by:	7	Prototype Approval:	N/A
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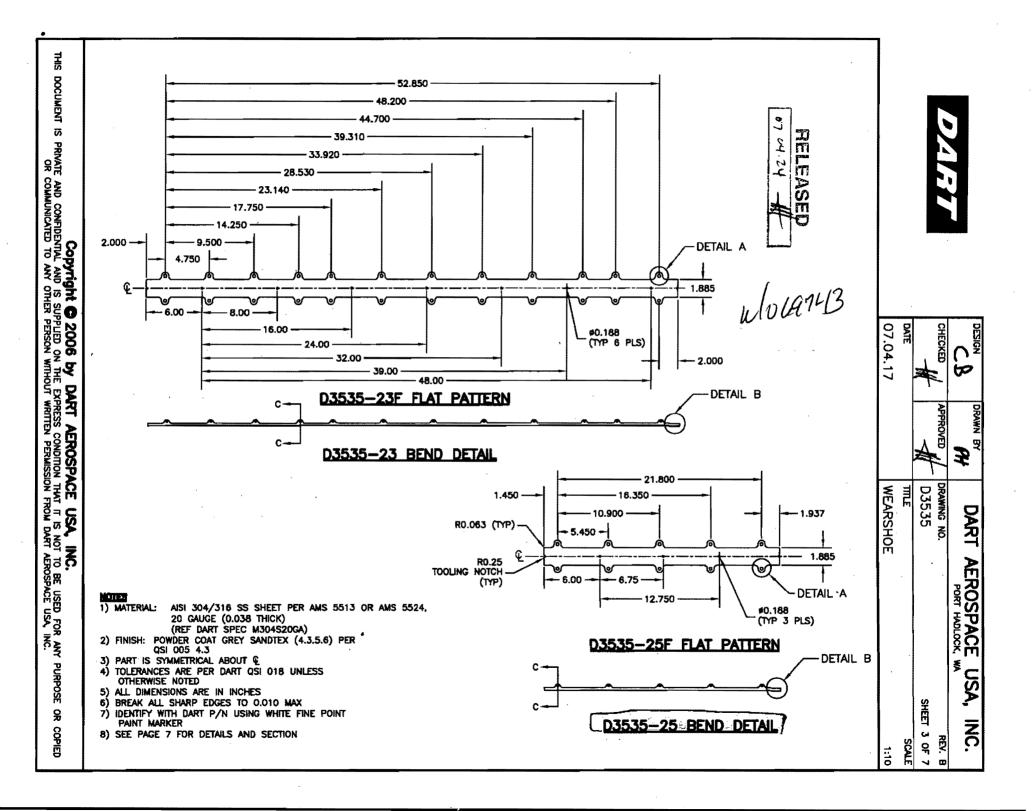
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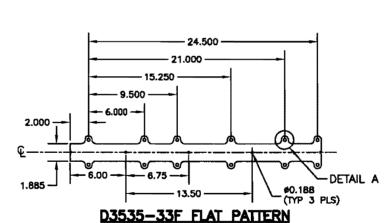
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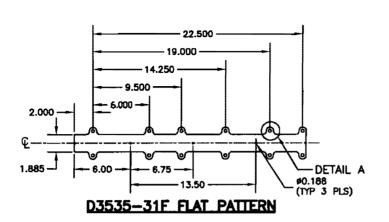
07.04.17

WEARSHOE











D3535-31 BEND DETAIL

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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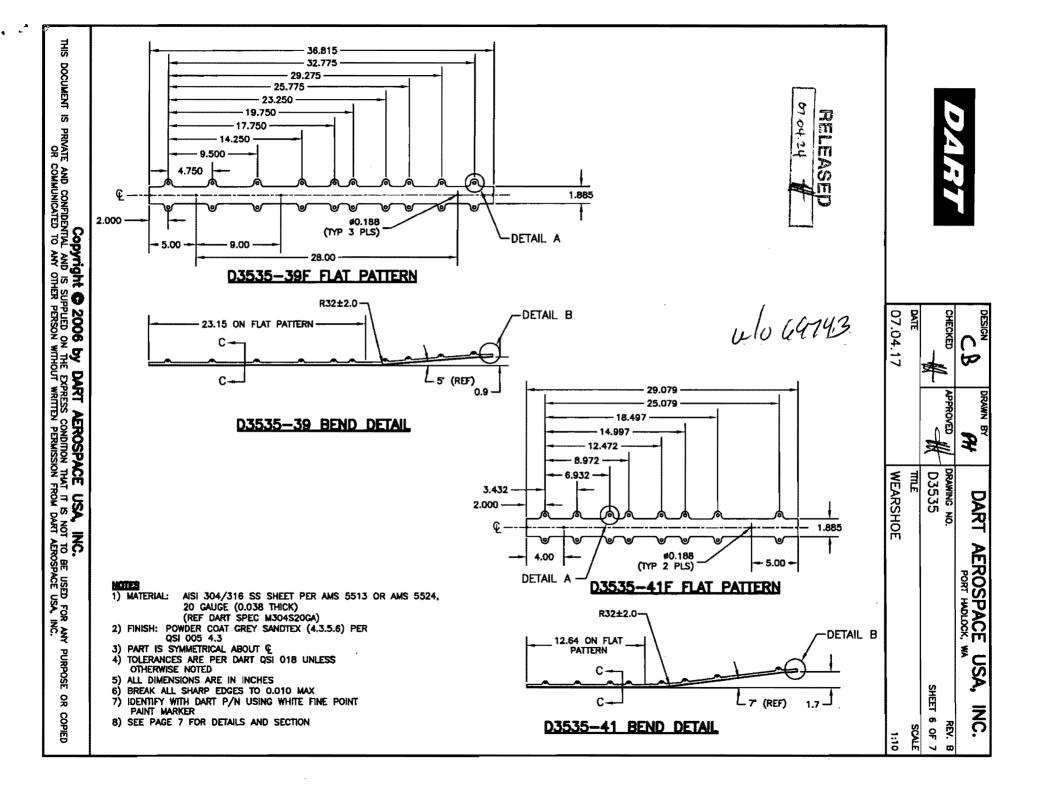




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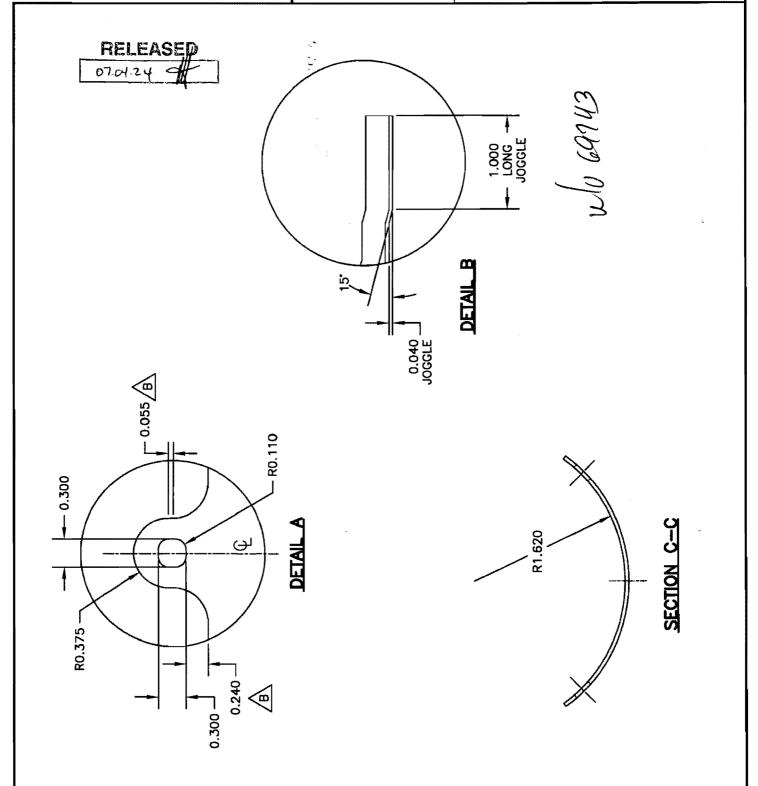
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